

Date: Monday, 08/06/2009 10:24:53 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : JOGGLE BRACKET
Job Number : 48399	
Estimate Number : 12912	
P.O. Number :	Part Number : D35801
This Issue : 08/06/2009 S.O. No. :	Drawing Number : D3580 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 47787	Material :
Written By :	Due Date : 15/06/2009 Qty: 100 Um: Each
Checked & Approved By :	
Comment : Est Rev :A New Issue 07.06.25 EC	
Est Rev:B Removed Powder Coat 07-07-11 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S18GA	304/316 .050 Sheet
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Comment: Qty.: 0.0105 sf(s)/Unit Total : 1.0500 sf(s)
 304/316 SS sheet 0.050" thick
 Batch: 111743 B 9-6-9

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3580
 Dwg Rev: B
 Prog Rev: B B 9-6-9

2-Deburr if necessary

(150)

09/06/10

150X Counted

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

B 9-6-9

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

counted
 09/06/10 (150)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: Bend as per dwg D3580 using 1/8" offset die

SB 09/06/10 (150)

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

508/66/15 *count* *(150)*

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *115*

9/4/16

(1500)
Se

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/17 *df*

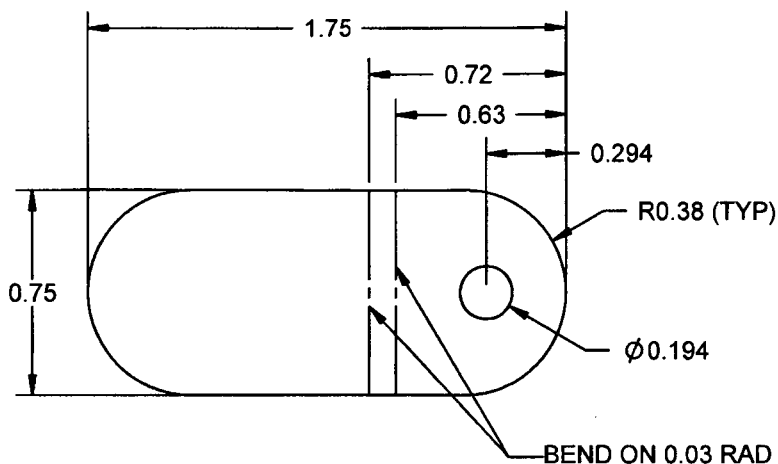
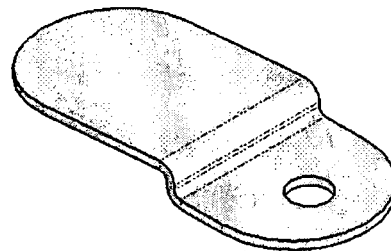
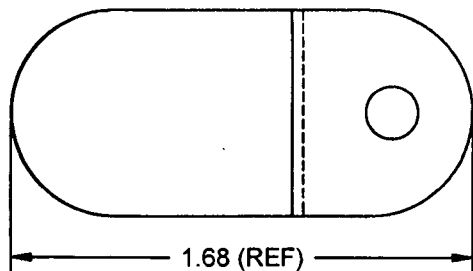
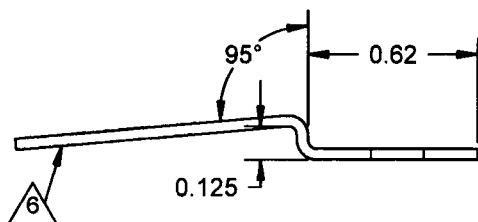
Job Completion



MF
09-06-16

DART

DESIGN <i>LE</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3580	REV. B SHEET 1 OF 1
DATE 07.07.09	TITLE JOGGLE BRACKET		SCALE 3:2
REV	DATE	DESCRIPTION	
A	07.05.15	NEW ISSUE	
B	07.07.09	REMOVE POWDER COAT	

RELEASED07.07.09 *[Signature]***D3580-1F FLAT PATTERN****D3580-1 JOGGLE BRACKET****NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 18 GAUGE (0.050 THICK)
PER MIL-S-5019 (REF DART SPEC M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 6) IDENTIFY WITH DART P/N "D3580-1" USING FINE POINT PERMANENT INK MARKER
ON THE UNDERSIDE OF THE PART AS INDICATED

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